

# Work Order ID 72115

Tuesday, July 19, 2011 11:19:56 AM



Page 1

Item ID: D139-799-013

Accept



Setup Start



Revision ID:

Stop



Item Name: Cargo Door Hinge

Start Date: 7/19/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 7/25/2011 Req'd Qty: 2.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

11-07-19

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

IIN-D139-799

D

100

0.00



DC

Document Control

Memo

0.00

Photocopy bluefile & type labels per PPP D139-799-013  
CHG002

11/7/27 07 28 (2)  
JG for BG 11-7-27 (2)

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

11/7/27 07 28 (2)

120

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

11/7/27 07 28 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 72115**

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Item ID: D139-799-013

Accept



Setup Start



Revision ID:

Stop



Item Name: Cargo Door Hinge

Start Date: 7/19/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 7/25/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 		0.00							
Packaging									
Packaging	Memo Identify and pack for shipping as per PPP D139-799-013 Location: <u>Snaf</u> PPP rev: <u>Snaf</u>	0.00							
140 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							

11/2/2011

20

11/7/29

11-07-28

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, July 19, 2011 11:20:04 AM

Page 1

Work Order ID: 72115

Parent Item: D139-799-013

Parent Item Name: Cargo Door Hinge



Start Date: 7/19/2011






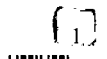






Required Date: 7/25/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 10.06.08 new issue DD verf:JLM  
AS PER ECN 11-598 11-06-05 JLM VERIFIED BY:DD

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
 D2585  x2 Mounting Channel		Manufactured	No			110	Each	75.0000		2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST017		75							
				69536		19							
				70814		56							
 D2586  x2 Door Latch		Manufactured	No			110	Each	98.0000					
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST204		98							
				64774		48							
				70557		50							
 D2621  x2 Latch Plate, 350 Spacepod		Manufactured	No			110	Each	34.0000					
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST019		34							
				56526		34							
 D3552-13  x2 Door Prop		Manufactured	No			110	Each	11.0000		2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST272A		11							
				56392		1							
				69668		10							

Handwritten notes: 11/12/27sf (2)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 72115

Parent Item: D139-799-013

Parent Item Name: Cargo Door Hinge

Start Date: 7/19/2011

Required Date: 7/25/2011

Start Qty: 2.00

Required Qty: 2.00

D3622-1  
Ball Stud

Manufactured No 110 Each 36.0000

Location Loc Qty Loc Code

ST070 36  
67284 15  
71540 21

D3622-3  
Ball Stud

Manufactured No 110 Each 42.0000

Location Loc Qty Loc Code

ST070 42  
52939 2  
53951 40

D4072-1  
Airframe Hinge

Manufactured No 110 Each 0.0000

D4072-3  
Airframe Hinge Backing Plate

Manufactured No 110 Each 24.0000

Location Loc Qty Loc Code

ST119 24  
71536 24

D4072-5  
Bushing

Manufactured No 110 Each 27.0000

Location Loc Qty Loc Code

ST119 27  
62804 2  
71537 25

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 72115

Parent Item: D139-799-013

Parent Item Name: Cargo Door Hinge

Start Date: 7/19/2011

Required Date: 7/25/2011

Start Qty: 2.00

Required Qty: 2.00



Door Hinge



Door Hinge Backing Plate

Manufactured No 110 Each 0.0000



4

B715395

Manufactured No 110 Each 22.0000



4

2

## Location

## Loc Qty

## Loc Code

ST120

22

65947

2

71541

20

4

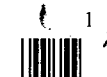


Bracket



Channel

Manufactured No 110 Each 0.0000



2

B715425

Manufactured No 110 Each 19.0000



2

B724035

## Location

## Loc Qty

## Loc Code

ST120

19

62797

1

71543

18

2



Backing Plate



Striker Plate

Manufactured No 110 Each 0.0000



2

B715445

Manufactured No 110 Each 1.0000



2

B72112 11/1/12

## Location

## Loc Qty

## Loc Code

ST120

1

62799

1

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Tuesday, July 19, 2011 11:20:05 AM

Work Order ID: 72115

Parent Item: D139-799-013

Parent Item Name: Cargo Door Hinge

Start Date: 7/19/2011

Required Date: 7/25/2011

Start Qty: 2.00

Required Qty: 2.00

MS21042L3-  
X2  
Nut



Purchased No

110 Each

1,618.000

(20) 40



sl

Location

Loc Qty

Loc Code

ST300

1618

117441

786

117601

400

117885

432

40

MS21042L5  
X2  
Nut



Purchased No

110 Each

1,344.000

(1) 2



sl

Location

Loc Qty

Loc Code

ST300

1344

116105

5

116548

155

117441

498

117591

100

117611

90

118179

496

2

MS27039-1-10  
X2  
Screw



Purchased No

110 Each

187.0000

(8) 16



11/7/27 sl 20

Location

Loc Qty

Loc Code

ST290

150

117441

150

ST291

37

115935

37

11

3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Tuesday, July 19, 2011 11:20:05 AM

Work Order ID: 72115

Parent Item: D139-799-013

Parent Item Name: Cargo Door Hinge

Start Date: 7/19/2011

Required Date: 7/25/2011

Start Qty: 2.00

Required Qty: 2.00

MS27039-1-14 } Purchased No  
Screw

110 Each 140.0000

Location Loc Qty Loc Code

MEZZ 140  
112312 100  
15924 40

MS27039-1-16 } Purchased No  
Screw

Each 0.0000

MS27039-1-17 } Purchased No  
Screw

110 Each 122.0000

Location Loc Qty Loc Code

ST292 122  
11540 22  
117591 100

NAS1149D0363J } Purchased No  
Washer

110 Each 3,005.000

Location Loc Qty Loc Code

ST298 3005  
117291 30  
117505 500  
117601 475  
118077 2000

6 2 4  
sf

16  
M11384 sf

2  
sf

18 36  
M113288 M116007

2x  
11/7/27

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Tuesday, July 19, 2011 11:20:06 AM

Work Order ID: 72115

Parent Item: D139-799-013

Parent Item Name: Cargo Door Hinge

Start Date: 7/19/2011

Required Date: 7/25/2011

Start Qty: 2.00

Required Qty: 2.00

NAS1149D0663J

Purchased

No

110

Each

639.0000



Washer

## Location

## Loc Qty

## Loc Code

ST298

639

115996

5

117291

134

117977

500

110

Each

56.0000

NAS1515H5L

Purchased

No



WASHER

## Location

## Loc Qty

## Loc Code

FG

40

103691

40

ST277

16

111359

16



2

8

m118378

11/7/275/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



## 5.0 PARTS LIST

Qty -011	Qty -012	Qty -013	Qty -015	Qty -017	Part Number	Description
X					D139-799-011	MAINTENANCE STEP KIT
	X				D139-799-012	MAINTENANCE STEP KIT
		X			D139-799-013	CARGO DOOR HINGE KIT
			X		D139-799-015	ENGINE WASH KIT
				X	D139-799-017	FLOOR PROTECTOR KIT
		1			D2585	MOUNTING CHANNEL
		1			D2586	DOOR LATCH
		1			D2621	LATCH PLATE
		1			D3552-13	DOOR PROP
				2	D3580-1	JOGGLE BRACKET
		1			D3622-1	BALL STUD
		1			D3622-3	BALL STUD
				2	D3628-1	CUPPED WASHER
		2			D4072-1	AIRFRAME HINGE
		2			D4072-3	AIRFRAME HINGE BACKING PLATE
		4			D4072-5	BUSHING
		2			D4073-1	DOOR HINGE
		2			D4073-3	DOOR HINGE BACKING PLATE
		1			D4074-1	BRACKET
		1			D4074-3	CHANNEL
		1			D4074-5	BACKING PLATE
		1			D4074-7	STRIKER PLATE
1					D4092-041	MAINTENANCE STEP ASSEMBLY
	1				D4092-042	MAINTENANCE STEP ASSEMBLY
			2		D4121-1	HOSE ASSEMBLY
			1		D4121-3	HOSE ASSEMBLY
			1		D4121-5	HOSE ASSEMBLY
				1	D4130-5	FWD CARGO FLOOR PROTECTOR
				1	D4130-7	CENTER CARGO FLOOR PROTECTOR
				1	D4130-9	AFT CARGO FLOOR PROTECTOR
			1		D4131-041	MANIFOLD ASSEMBLY
			1		D4131-043	DOUBLER ASSEMBLY
			2		D4146-1	FITTING
				2	D4153-1	JOGGLE BRACKET
				2	D4166-1	PLACARD, MAX LOAD
			2		D4182-1	FITTING, QUICK DISCONNECT
			1		D4384-1	PLACARD
4	4				AN6H12	BOLT
			4		AN526-1032R16	SCREW
			2		AN832-6J	UNION
			4		AN924-6J	NUT
		20			MS21042L3	NUT (OR MS21042-3)
		1			MS21042L5	NUT (OR MS21042-5)
			20		MS21919WDG09	CLAMP
		8			MS27039-1-10	SCREW
		2			MS27039-1-14	SCREW
		8			MS27039-1-16	SCREW
		1			MS27039-1-17	SCREW
		18			NAS1149D0363J	WASHER (or AN960JD10)
6	6	1			NAS1149D0663J	WASHER (or AN960JD616)
			2		NAS1149C0932R	WASHER (or AN960C916L)
		4			NAS1515H-5L	WASHER

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Revision: D  
Date: 11.06.10